

Work Order ID 56211

February 16, 2010 12:36:33 PM

Page 1

Item ID: D3608-1

Revision ID:

Item Name: Lower Doubler

Start Date: 2/16/10 Start Qty: 4.00

Required Date: 2/19/10 Req'd Qty: 4.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3608

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3608

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

10-2-17

4

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-2-17

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/15

10-2-17

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56211

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Item ID: D3608-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lower Doubler

Start Date: 2/16/10 Start Qty: 4.00



Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

10-2-18

(42) SJ

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/18
MF
10-2-18.

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Picklist Print

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Page 1
T

Work Order ID: 56211



Parent Item: D3608-1



Parent Item Name: Lower Doubler

Start Date: 2/16/10

Required Date: 2/19/10

Comments: IPP Rev:A New Issue 07-03-26 JLM
IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP
Rev:D 10.02.16 rev.B as per dwg DD verified by:EC

Start Qty: 4.00

Required Qty: 4.00

M304S20GA

Purchased

No

100

sf

179.2294 3.1124



304/316 .040 Sheet

B10-2-17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

179.2294053

110076

0.40253684

112567

38.0765789

112885

36.9578

113062

95.2723

113077

8.52018947

112885

(4)

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DART AEROSPACE LTD		Work Order: S6211
Description: Lower Doubler		Part Number: D3608-1
Inspection Dwg: D3608-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

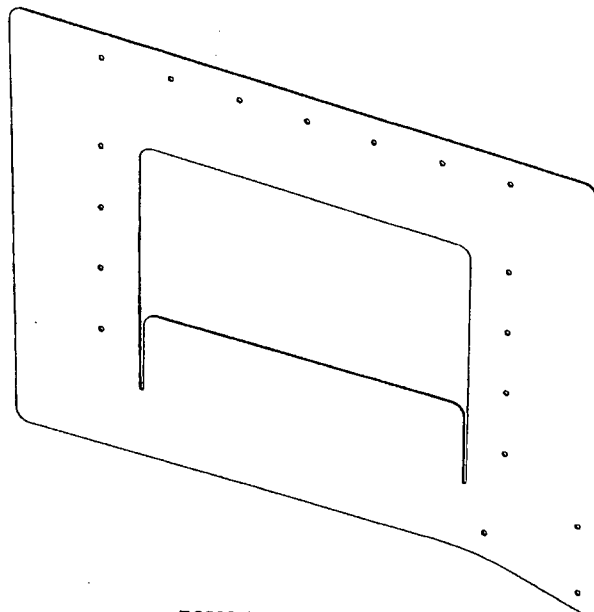
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .698	+ .004 - .001	.694	✓			
1.83	± .030	1.821	✓			
.50	± .030	.501	✓			
8.100	± .010	8.095	✓			
1.350	± .010	1.344	✓			
2.06	± .030	2.065	✓			
2.51	± .030	2.507	✓			
3.750	± .010	3.748	✓			
1.250	± .010	1.244	✓			
8.90	± .030	8.900	✓			
.400	± .010	.398	✓			
1.350	± .010	1.353	✓			
.345	± .010	.345	✓			
1.875	± .010	1.870	✓			
.423	± .010	.427	✓			
6.42	± .030	6.411	✓			
2.90	± .030	2.907	✓			
6.35	± .030	6.346	✓			
.75	± .030	.752	✓			
2.43	± .030	2.440	✓			
1.34	± .030	1.342	✓			
8.44	± .030	8.439	✓			
2.49	± .030	2.505	✓			
.040	± .010	.034	✓			

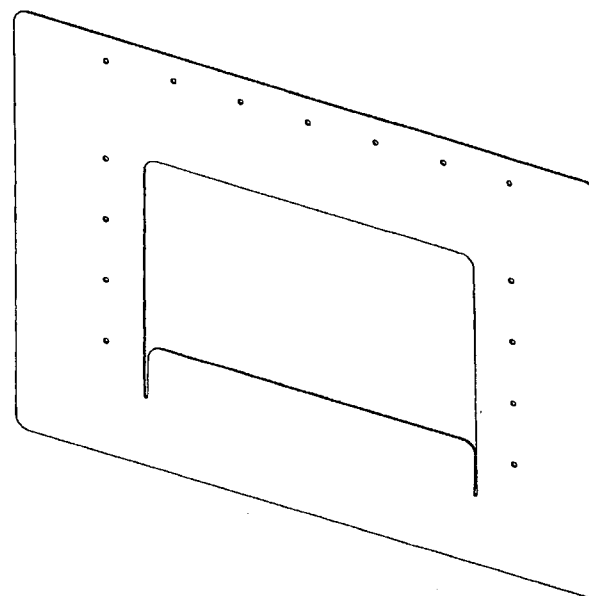
Measured by: RB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 10-2-17	Date: 10/02/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

w/o 5624



D3608-1 LOWER DOUBLER



D3608-3 UPPER DOUBLER

RELEASED
2010-02-10
JMP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK
PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3608-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.80 lbs EACH

B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARD; ELIMINATED D3608-1FA-3F; DELETED BENDING DETAILS. REASON: D3608-1/3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-097.	MB	10.02.05
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3608	REV. B SHEET 1 OF 3
TITLE DOUBLER	SCALE NTS
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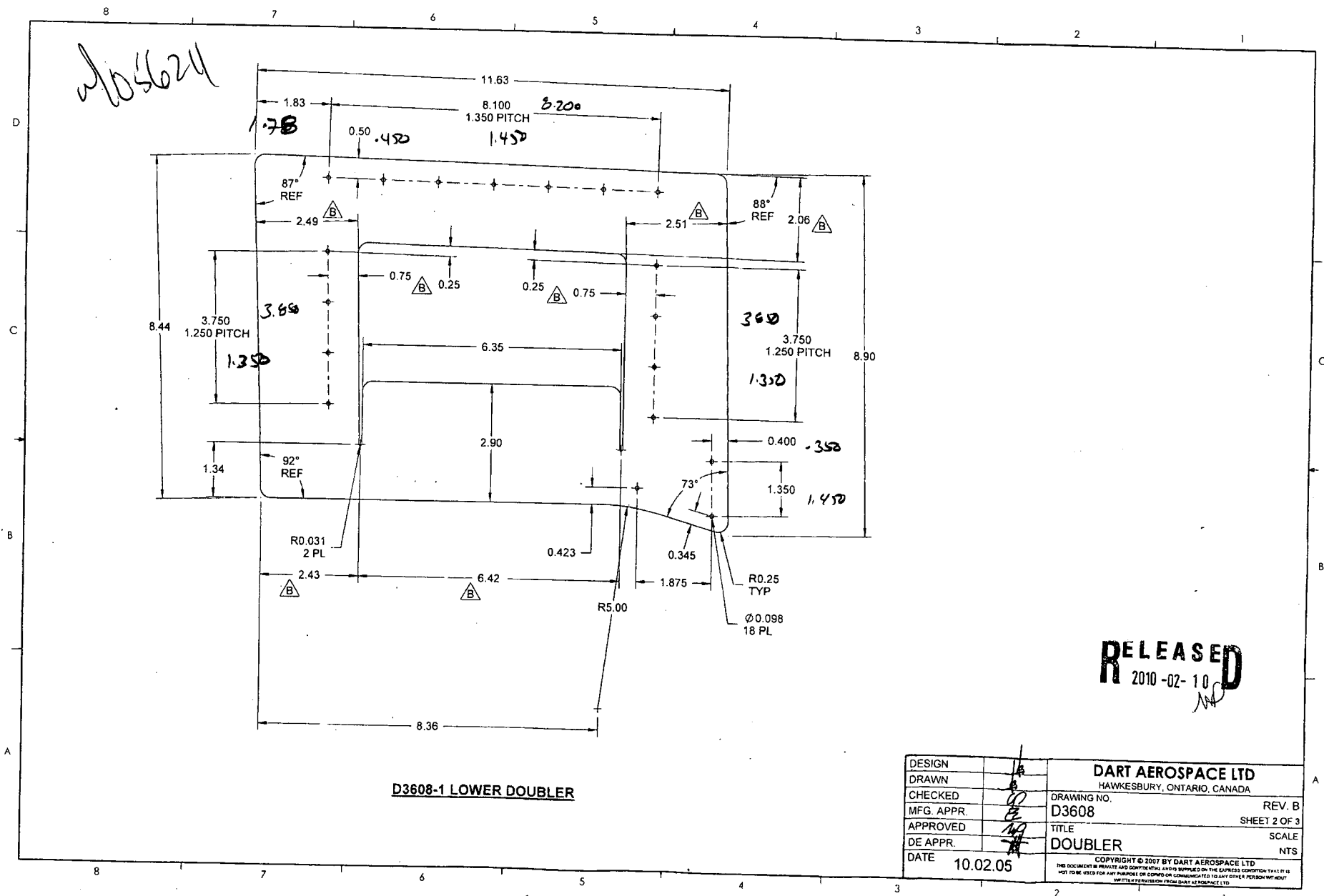
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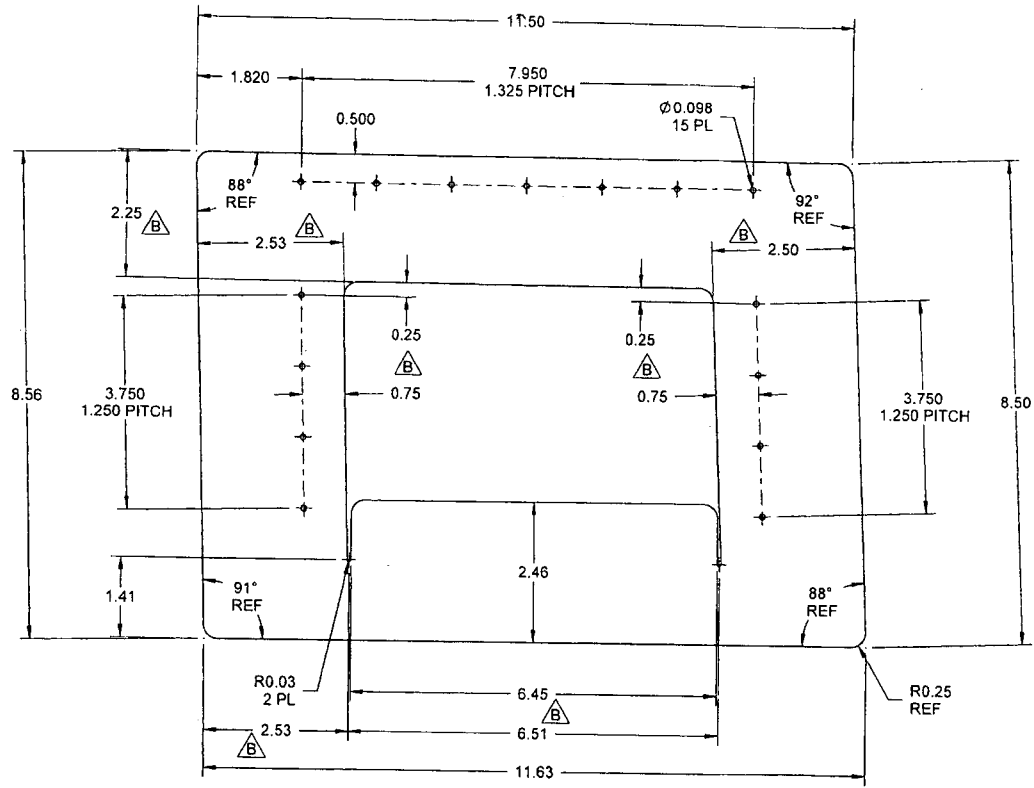
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W/O 56211



D3608-3 UPPER DOUBLER

RELEASED
2010-02-18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3608	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	10.02.05	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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